

Work Order ID 63157

Thursday, October 21, 2010 3:55:33 PM



Page 1

Item ID: D412-704-041

Accept



Setup Start



Revision ID:

Stop



Item Name: Pedal Assembly (205/212/214/412)

Start Date: 10/21/2010 Start Qty: 1.00



Cust Item ID:

Required Date: 10/28/2010 Req'd Qty: 1.00



Customer:

Reference:

Run Start



Approvals:

Process Plan:

[Signature]

Date: 10/22/22

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr

Revision Nbr

D412-704-041

Rev A

100

0.00



Small Fab

Small Fab

Memo

0.00

Small Fab

Assemble pedal as per Dwg D412-704-041
Tighten & Torque Bolts as per Dwg D412-704-041

EP 10/10/25 (D)

110

QC5- Inspect part completeness to step on W/O

0.00



QC

Memo

0.00

Quality Control

8/10/10/24

(X)

120

Pick Kit

0.00



Packaging

Memo

0.00

Packaging

10/10/201 SP (X)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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Setup Start

Revision ID:

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Item Name: Pedal Assembly (205/212/214/412)

Start Date: 10/21/2010 Start Qty: 1.00

Cust Item ID:

Required Date: 10/28/2010 Req'd Qty: 1.00

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

130

QC4- 100% Inspect kits for completeness

0.00

Solve



QC

Memo

0.00

Quality Control

140

Identify as per dwg & Stock Location: _____

0.00



Packaging

Memo

0.00

Packaging

150

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

C 10/14/20 (1)

10/10/29 J
B9/10-10-25
(1)

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Picklist Print

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Work Order ID: 63157

Parent Item: D412-704-041

Parent Item Name: Pedal Assembly (205/212/214/412)




Start Date: 10/21/2010

Required Date: 10/28/2010

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP Rev:B 05.01.28 Removed hardware on Step 2; Added Figures 1-3 KJ/RF
 IPP Rev:C 06.03.08 Re-format EC
 IPP Rev:D 07-03-20 Added Dwg D412-704-041 07-03-20 JLM
 IPP Rev:E 07.05.02 Reformat EC
 IPP Rev:F 08-10-08 as per revB DD veriified by:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
AN3-10A  Bolt		Purchased	No			100	Each	69.0000	1	1			
<div> <div>Location</div> <div>ST351</div> <div>115016</div> <div>115877</div> </div> <div> <div>Loc Qty</div> <div>69</div> <div>19</div> <div>50</div> </div> <div> <div>Loc Code</div> <div></div> <div></div> <div></div> </div>													
AN315-4R  Nut		Purchased	No			100	Each	58.0000	1	1			
<div> <div>Location</div> <div>ST324</div> <div>17566</div> </div> <div> <div>Loc Qty</div> <div>58</div> <div>58</div> </div> <div> <div>Loc Code</div> <div></div> <div></div> </div>													
AN4-10A  Bolt		Purchased	No			100	Each	100.0000	1	1			
<div> <div>Location</div> <div>ST356</div> <div>113422</div> <div>114523</div> <div>115835</div> </div> <div> <div>Loc Qty</div> <div>100</div> <div>1</div> <div>59</div> <div>40</div> </div> <div> <div>Loc Code</div> <div></div> <div></div> <div></div> <div></div> </div>													

62939

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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Page 2

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Work Order ID: 63157

Parent Item: D412-704-041

Parent Item Name: Pedal Assembly (205/212/214/412)

Start Date: 10/21/2010

Required Date: 10/28/2010

Start Qty: 1.00

Required Qty: 1.00

AN4-12A Purchased No

100 Each

306.0000

2

2



Bolt

Location

Loc Qty

Loc Code

ST357

306

112314

106

115371

40

115422

160

AN4-13A Purchased No

100 Each

502.0000

1

1



Bolt

Location

Loc Qty

Loc Code

ST357

300

115936

300

ST358

202

115159

202

AN960JD10 NAS1149D0363J Purchased No

100 Each

8.0000

5

5



Washer

4 M115622 (52)

Location

Loc Qty

Loc Code

ST

6

107715

6

ST335

2

105792

2

AN960JD416 NAS1149D0463J Purchased No

100 Each

24.0000

11

11



Washer

4 M115622 (11A)

Location

Loc Qty

Loc Code

ST300

24

113288

24

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Page 2

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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Work Order ID: 63157

Parent Item: D412-704-041

Parent Item Name: Pedal Assembly (205/212/214/412)

Start Date: 10/21/2010

Required Date: 10/28/2010

Start Qty: 1.00

Required Qty: 1.00

AN960JD416L NAS1149D0416J Purchased No

100

Each

219.0000

3

3



Washer

Location

Loc Qty

Loc Code

ST346

219

106785

2

110153

217

D3204-041 Manufactured No

100

Each

4.0000

1

1



Release Pedal Assembly

Location

Loc Qty

Loc Code

ST197

4

60509

4

D3205-1 Manufactured No

100

Each

4.0000

1

1



Pedal Bracket

Location

Loc Qty

Loc Code

ST197

4

55731

4

D3205-3 Manufactured No

100

Each

6.0000

1

1



Back Plate

Location

Loc Qty

Loc Code

ST197

6

47491

6

D3206-1 Manufactured No

100

Each

9.0000

1

1



Pedal Arm

Location

Loc Qty

Loc Code

ST197

9

55732

9

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W/O:		WORK ORDER CHANGES					
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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Work Order ID: 63157

Parent Item: D412-704-041

Parent Item Name: Pedal Assembly (205/212/214/412)

Start Date: 10/21/2010

Required Date: 10/28/2010

Start Qty: 1.00

Required Qty: 1.00

D3209-041

Manufactured No

100

Each

5.0000

1

1



Bracket Assembly



EB 10/10/25

Location

Loc Qty

Loc Code

ST045

1

58265

1

ST202

4

60295

4

MS21042L3

Purchased

No

100

Each

2,338.000

1

1



Nut



EB 10/10/25

Location

Loc Qty

Loc Code

ST300

2338

114523

49

114784

1289

115835

1000

MS21042L4

Purchased

No

100

Each

3,253.000

5

5



Nut



EB 10/10/25

Location

Loc Qty

Loc Code

ST300

3253

113422

68

114523

8

114718

16

114784

32

115108

129

115589

1900

115621

1100

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W/O:		WORK ORDER CHANGES					
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Work Order ID: 63157

Parent Item: D412-704-041

Parent Item Name: Pedal Assembly (205/212/214/412)

Start Date: 10/21/2010

Required Date: 10/28/2010

Start Qty: 1.00

Required Qty: 1.00

MS24694-S102

Purchased

No

100

Each

54.0000

1

1



Screw

Location

Loc Qty

Loc Code

ST288

50

114382

50

ST289A

4

113644

4

MS9519-10

Purchased

No

100

Each

36.0000

1

1



Bolt

Location

Loc Qty

Loc Code

ST297

36

100290

36

AN3-6A

Purchased

No

120

Each

208.0000

2

2



Bolt

Location

Loc Qty

Loc Code

ST351

208

113359

8

114941

200

AN960JD10L

NAS1149D0332J

Purchased

No

120

Each

0.0000

4

4



Washer

Thursday, October 21, 2010 3:55:37 PM

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Dart Aerospace Ltd

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Parent Item: D412-704-041

Parent Item Name: Pedal Assembly (205/212/214/412)



Start Date: 10/21/2010

Required Date: 10/28/2010

Start Qty: 1.00

Required Qty: 1.00

MS21042L3

Purchased

No

120

Each

2,338.000

1

2



Nut



10/21/2010

Location

Loc Qty

Loc Code

ST300

2338

114523

49

114784

1289

115835

1000

2

Thursday, October 21, 2010 3:55:37 PM

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Page 6

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

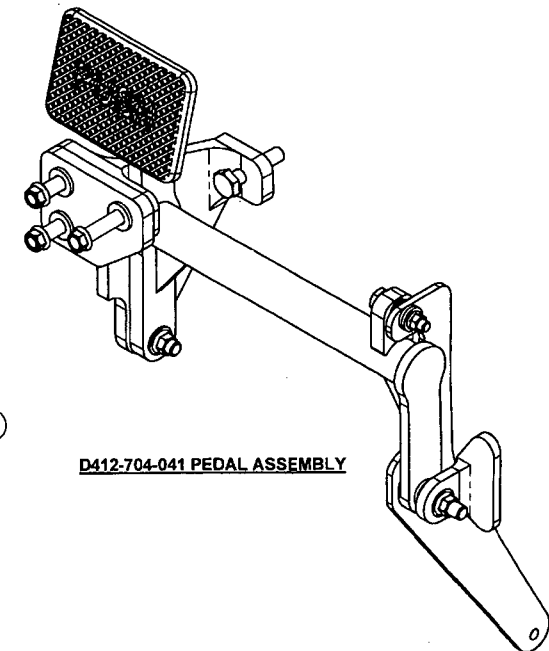
Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

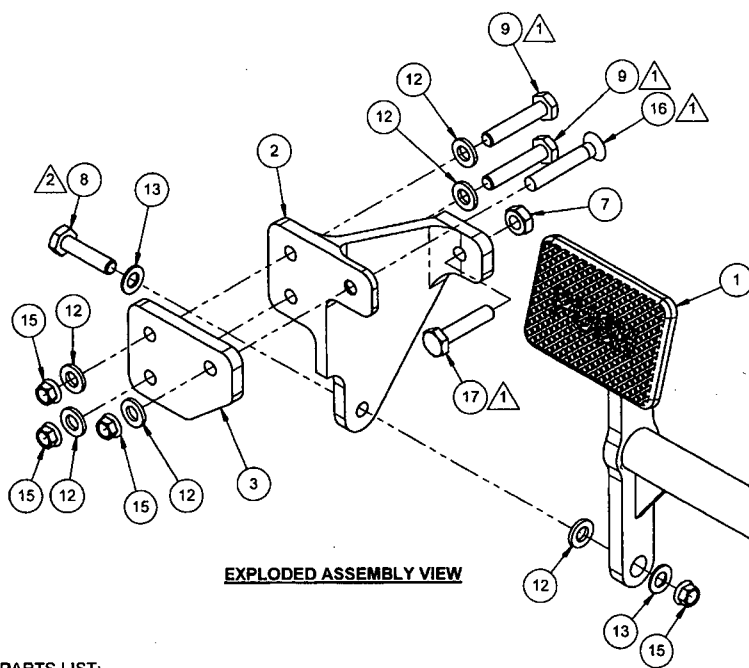
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SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 63157
10-10-22



D412-704-041 PEDAL ASSEMBLY



EXPLODED ASSEMBLY VIEW

PARTS LIST:

ITEM	QTY	P/N	DESCRIPTION
-	X	D412-704-041	PEDAL ASSEMBLY
1	1	D3204-041	PEDAL WELDMENT
2	1	D3205-1	PEDAL BRACKET
3	1	D3205-3	BACK PLATE
4	1	D3206-1	PEDAL ARM
5	1	D3209-041	BRACKET ASSEMBLY
6	1	AN3-10A	BOLT
7	1	AN315-4R	NUT
8	1	AN4-10A	BOLT
9	2	AN4-12A	BOLT
10	1	AN4-13A	BOLT
11	5	AN960JD10	WASHER
12	11	AN960JD416	WASHER
13	3	AN960JD416L	WASHER
14	1	MS21042L3	NUT (OR MS21042-3)
15	5	MS21042L4	NUT (OR MS21042-4)
16	1	MS24694-S102	SCREW
17	1	MS9519-10	BOLT
N/A*	2	AN3-6A	BOLT
N/A*	4	AN960JD10L	WASHER
N/A*	2	MS21042L3	NUT (OR MS21042-3)

* SHIPPED LOOSE WITH -041 KIT (NOT PRE-ASSEMBLED AT DART)

NOTES:

- 1 INSTALL IDENTIFIED FASTENERS LOOSE (HAND TIGHTEN ONLY).
- 2 TIGHTEN IDENTIFIED FASTENERS UNTIL SNUG. ENSURE THAT PARTS CAN STILL ROTATE.
- 3 TORQUE IDENTIFIED FASTENERS TO 15-25 in-lbs (1.7-2.8 N-m).

RELEASED

07 01 30

A		07.01.23		NEW ISSUE	
REV	DATE	DESCRIPTION			
DESIGN	DRAWN BY	DART AEROSPACE LTD			
C.B.	C.B.	HAWKESBURY, ONTARIO, CANADA			
CHECKED	APPROVED	DRAWING NO.		REV. A	
LE	#	D412-704-041		SHEET 1 OF 1	
DATE	TITLE	SCALE			
07.01.23	PEDAL ASSEMBLY	1:2			
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